



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

9016
Dec 2

RB T102064-3
Job Sheet 184075



Part No: RB T102064-3

Job Qty: 12 ea

Part Name: Screw Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/2/18

Job Tracking No:

Due Date: 10/22/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG T102064 Rev. A IPP Rev. 3 18.10.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	12 Ea		10/22/18	0.00	0.00	Start Up Large Fab-7		ER
110	Large Fab	12 pcs		10/22/18	0.00	1.20	Large Fab 3		ER
120	QC	12 pcs		10/22/18	0.00	0.00	QC9		LPC
125	QC	12 pcs		10/22/18	0.00	0.00	QC5		CP
126	Outsource	12 pcs	JAN 15 2019	10/22/18	0.00	0.00	Outsource1 Atlantic	8	CC 19-01-08
130	Outsource	12 pcs		10/22/18			GRO002-VC		21 JAN 22 2019
140	Packaging	12 pcs		10/22/18	0.00	0.00	Packaging2		388
150	QC	12 pcs		10/22/18	0.00	0.00	QC6		Dan
160	Packaging	12 pcs		10/22/18	0.00	0.00	Packaging3-2		DAS
170	QC21-SA	12 Ea		10/22/18	0.00	0.00	QC21		GAISOB

Part Op 110 - 1-Weld as per DWG.

Descriptions: 125 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.

126 - 1-Issue P/O to METCORE; P/O 042206 RC 2-Bead blast 3--Material type; 4130 4-Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER METCORE to ship directly to GROUPE ALTECH***

130 - -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Material type; 4130 -Certificate of Conformity is required

160 - Bag and label

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB T102064-5	Screw	12 Ea (1 ea)	100-Start up Operation	5141046
RB T102064-7	Handle	12 Ea (1 ea)	100-Start up Operation	5141040



Container No: S142205



Part: RB T102064-3

Job No: 184075

Serial No/Batch: S142205

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Allocations

Required	Inventory	Allocated
12	0	0
12	0	0

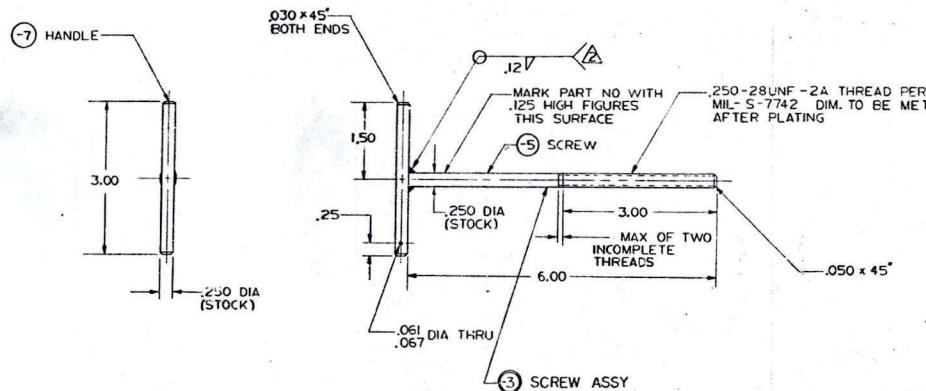
Plex 10/2/18 12:02 PM dart.lacelle.linda

Date: 01/07/19

Part Specifications
Specifications could not be found.

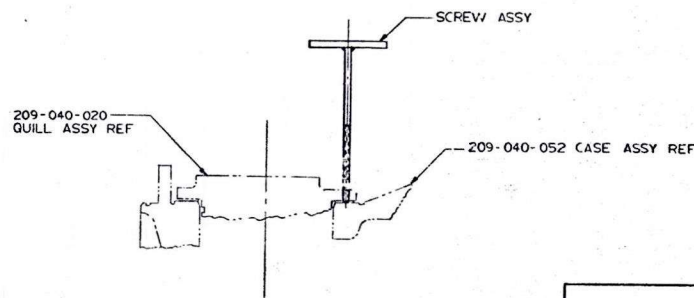
Plex 10/2/18 12:02 PM dart.lacelle.linda

REVISIONS			
LTB	DESCRIPTION	DATE	APPROVED
A	CHG FROM TEST TO PROD DWG		
	REF TEST E.O. ASS2-40-02	3-18-79	ABRAHAM



NOTES:

- HEAT TREAT PER MIL-H-6875 TO 160-180 KSI TENSILE
- WELD PER MIL-W-8611.
- CADMIUM PLATE PER FED SPEC QQ-P-416, CLASS 2, TYPE II
- USED TO REMOVE 209-040-030 RING GEAR, 209-040-050 TOP CASE, 209-040-130 JET ASSY, 209-040-020, 209-040-022, 214-04-026, 209-040-021, 214-040-027 QUILL ASSEMBLIES AND 214-040-059 SLEEVE.
- LOCKWIRE FOUR -3 SCREW ASSEMBLIES TOGETHER AND STOCK AS JACK SCREW SET. TAG WITH PART NUMBER PER BPS FW 4050.



TYPICAL APPLICATION
SCALE 1/2

PROPRIETARY RIGHTS NOTICE THIS DATA IS PROPRIETARY TO BELL HELICOPTER COMPANY. REPRODUCTION, REPRODUCTION, OR USE OF THIS DATA FOR ANY PURPOSE IS FORBIDDEN WITHOUT WRITTEN AUTHORIZATION FROM BELL HELICOPTER COMPANY. THE FOREGOING DOES NOT APPLY TO VENDOR PARTS.		UNLESS OTHERWISE SPECIFIED: 1. MAKE PER BPS FW 4050 2. BREAK ALL SHARP EDGES 3. TORQUE PER BPS FW 4018 4. SAFETY PER BPS FW 4045 5. DIMENSIONAL LIMITS APPLY AFTER PLATING		APPLICABLE DOCUMENTS: IDENTIFICATION PER MIL-STD-12 DIMENSIONING AND TOLERANCING PER ASAS 1745 ELECTRICAL SYMBOLS PER ASAS 132.2 ELECTRICAL RFP DESIGNATIONS PER ASAS 132.16		HEAT TREAT FINISH DATES OF REVIEWS QUANTITIES GROUPS PER		CONTRACT DATA DRAWING NO. DRAWING TITLE DRAWING SCALE DRAWING DATE DRAWING BY DRAWING CHECKED DRAWING APPROVED		BELL HELICOPTER COMPANY TITLE SCREW SET-JACKING, TRANSMISSION	
PART OR IDENTIFYING NO. 209-040-021 209-040-005 209-040-004		CODE AH-1T AH-1T AH-1T		NAME/INITIALS J. H. H.		STOCK SIZE 25 DIA x 3.3 25 DIA x 6.4 25 DIA x 6.4		MATERIAL 7130 ALY STL COML 7130 ALY STL COML 7130 ALY STL COML		MATERIAL SPEC 7130 ALY STL COML 7130 ALY STL COML 7130 ALY STL COML	
DASH NO. 125		NEXT ASSY USED ON APPLICATION		MACHINE SURFACES ENDS AT NOTED		SET DESIGN PROJECT 10/1/79		CODE IDENT NO. D 97499		DRAWING NO. T102064	
SCALE 1/2 IN/1 IN		SHEET 1 OF 1		DATE 10/1/79		DRAWN BY J. H. H.		CHECKED BY J. H. H.		APPROVED BY J. H. H.	

FILE COPY

T102064

A

10/1/79

10/1/79



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042206



Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO042206
PO Date: 1/8/19
Due Date: 1/14/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184075	RB T102064-3	Screw Assembly 1-Issue P/O to Atlantic; P/O _____ RC _____ 2-Bead blast 3--Material type; 4130 4- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER ATLANTIC to ship directly to GROUPE ALTECH***	Firmed	-	1/14/19	12 pcs	0 pcs	12 pcs	\$6.25/pcs	\$75.00
Grand Total:											\$75.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/8/19 1:22 PM dart.tsimiklis.chrisoula

Atlantic Heat Treating (2001) Ltd

Order No.: 161970

Ship Date: 9/1/2019

Shipping Ticket

Sold To: 1448
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To: 159025
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
PO042206 ✓				

Quantity	Part No. / Part Name / Part Description	Pounds
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✓ 12 PCS MATERIAL 4130
SANDBLAST AND HEAT TREAT TO 36-38RC
C OF C, PRT# RBT102064-3, JOB# 184075 ✓

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped:

12

Pounds Shipped:

1.00

Order No.: 161970

Shipped Complete

Quantity Shipped:

12.00

Received By:

Date:

Pounds Shipped:

1.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 01/09/2019

Certification

Date: 01/14/2019

Entry Date: 01/09/2019

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: PO042206

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
12	12 PCS MATERIAL 4130 SANDBLAST AND HEAT TREAT TO 36-38RC C OF C, PRT# RBT102064-3, JOB# 184075	1

Insp. Type	Scale	Minimum	Maximum	Number	Other
Customer Requirements:					

Harden rockwell

Results:

Harden ROCKWE	36.	38.	36. TESTED AS PER SAMPLING PLAN
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HEAT TREATED TO 36 RC AS PER CUSTOMER REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY): ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES) EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater


KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042276



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042276
PO Date: 1/15/19
Due Date: 1/22/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184075	RB T102064-3	Screw Assembly -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Material type; 4130 -Certificate of Conformity is required	Firmed	-	1/22/19	12 pcs	0 pcs	12 pcs	\$7.50/pcs	\$90.00

12 x JAN 22 2019

DAS
38
9-89

Grand Total: \$90.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

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Certificat de Conformité / Certificate of Compliance

(016077-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

016077 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
21-Jan-2019		Aman		042276				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT102064-3 ✓ Rev.	RBT102064-3 ZINC YELLOW AS PER ASTM B633 TYPE 2 SC 2	ZINC CH	12	12	0	0	0

 DAS
 38
 9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.